

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 73.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-004794**Date Inspected:** 25-Nov-2008**Project Name:** SAS Superstructure**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Contractor:** HoChang, Korea**OSM Arrival Time:** 800**OSM Departure Time:** 1900**Location:** Unyang, Korea**CWI Name:** N/A**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Pier E2 bearing and Shear key**Summary of Items Observed:**

The following report is based on METS observations at HoChang Machinery Industries. Current work: Casting, forging and machining.

On this date the Caltrans Quality Assurance (QA) inspector, Dong J. Shin arrived at HoChang Machinery Industries (HCMI) located at Unyang, Korea. The Purpose of this trip was to observe quality control during fabricate and process of following items.

Forging

1. Bearing Bottom Housing (B1-07/F07302-010): Move to HCMI for rough machining.
2. Bearing Bottom Housing (B2-07/F07302-020): Move to HCMI for rough machining.
3. Bearing Bottom Housing (B3-07/F07302-030): Move to HCMI for rough machining.
4. Bearing Bottom Housing (B4-07/F07302-040): Move to HCMI for rough machining.
5. Spherical Ring (S1-07/F07302-050): Dimension check after rough machining.
6. Spherical Ring (S2-07/F07302-060): Dimension check after rough machining.
7. Spherical Ring (S3-07/F07302-070): Dimension check after rough machining.
8. Spherical Ring (S4-07/F07302-080): Dimension check after rough machining.
9. Solid Shaft (B1-02/F07302-090): Dimension check after rough machining.
10. Solid Shaft (B2-02/F07302-100): Dimension check after rough machining.
11. Solid Shaft (B3-02/F07302-110): Dimension check after rough machining.
12. Solid Shaft (B4-02/F07302-120): Dimension check after rough machining.

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- F number is DooSan Production Number.
- B number is drawing Number .

Casting

1. Bearing Top Housing(B1-06, C07039-010): Cool down in mold.
2. Bearing Top Housing(B2-06, C07039-020): Pattern making
3. Bearing Top Housing(B3-06, C07039-030): Pattern making
4. Bearing Top Housing(B4-06, C07039-040): Pattern making
5. Bearing Hold Down Assembly (B1-01-1, C07039-050): Cool down in mold.
6. Bearing Hold Down Assembly (B1-01-2, C07039-060): Cool down in mold.
7. Bearing Hold Down Assembly (B2-01-1, C07039-070): Pattern making
8. Bearing Hold Down Assembly (B2-01-2, C07039-080): Pattern making
9. Bearing Hold Down Assembly (B3-01-1, C07039-170): Pattern making
10. Bearing Hold Down Assembly (B3-01-2, C07039-180): Pattern making
11. Bearing Hold Down Assembly (B4-01-1, C07039-190): Pattern making
12. Bearing Hold Down Assembly (B4-01-2, C07039-200): Pattern making
13. Shear Key Stub(S1-01, C07039-090) : Cool down in mold.
14. Shear Key Stub(S2-01, C07039-100) : Pattern making
15. Shear Key Stub(S3-01, C07039-110) : Pattern making
16. Shear Key Stub(S4-01, C07039-120) : Pattern making
17. Shear key Housing(S1-03, C07039-130): cool down
18. Shear key Housing(S1-03, C07039-130): cool down
19. Shear key Housing(S1-03, C07039-130): Pattern making
20. Shear key Housing(S1-03, C07039-130): Pattern making

- * S and B number is drawing number.
- * C number is DSHI ID number
- * Blank is not started.



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Summary of Conversations:

Discuss Mr. S. H. Kwak regarding current status of NDE procedure and fabrication procedure comments.

Check machining schedule of bearing bottom housing with Mr. Kwak.

Ask production schedule of casting.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Jinesh K, Mehta (951) 840-0541, who represents the Office of Structural Materials for your project.

Inspected By:	Shin,DJ	Quality Assurance Inspector
Reviewed By:	Lanz,Joe	QA Reviewer
